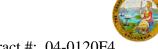
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-015088 Address: 333 Burma Road **Date Inspected:** 15-Jun-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** ZPMC and ABF **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component:** OBG 13 section

### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #14

Caltrans QA Inspector observed a ZPMC welder in process SMAW root pass process on base plates of 13AE section of east line. The weld and base plates ID are BP-3031-001-002/PL3218B and PL3219B with 100mm wall thick. The weld is designed CJP weld with SAW process welded in flat position. The SMAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 100mm wall thick base plate of 13AE section of east line. The weld number and plate number are BP-3031-001-002/PL3218B and PL3219B (side A). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. Caltrans QA Inspector observed two welders performed FCAW fillet weld process on stiffeners that connected to T-joint steel plate PL3390A of side plate #SP3098A with 22mm wall thick. The minimum preheat and maximum interpass temperature requirements for FCAW fillet weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #16

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 100mm wall thick base plate of 13AE section of west line. The weld number and plate number are BP3074-001-005/PL3361Cand PL3361C (side B). The semi-automatic saw process was monitored

# WELDING INSPECTION REPORT

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and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. **CLOSING STATEMENT** 

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

# **Summary of Conversations:**

As notes within report above

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer